

Work Order ID 139245 - 2

November 17, 2015 2:32:11 PM

139245

To ship Nov 25

Page 1

Item ID: D350-567-145

Accept

Revision ID:

N9000040100

Setup Start

NS1

Item Name: Floor Window Close Out (AS350 B3e)

Stop

NS2

Start Date: 11/17/2015 Start Qty: 2.00

2

Required Date: 11/25/2015 Req'd Qty: 2.00

2

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *SA*

Date: 11/11/17

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9590

F

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-567-145 CHG001

DAS
28
9-89

DEC 02 2015

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
27
9-89

DEC 02 2015

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
28
9-89

DEC 02 2015

Work Order ID 139245

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139245

Page 2

Item ID: D350-567-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Window Close Out (AS350 B3c)

Stop

NS2

Start Date: 11/17/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/25/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-567-145
Location:FG033

1X

DAS
28
3-99

DEC 02 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

15/12/2

51202

Picklist Print

November 17, 2015 2:32:17 PM

Page 1

Work Order ID: 139245

139245

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/17/2015

Required Date: 11/25/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CB200		Purchased	No				Each	27.0000		2			
-------	--	-----------	----	--	--	--	------	---------	--	---	--	--	--

CB200

Acrylic Adhesive, 3.5G

DAS
28
9-89

Location

Loc Qty

Loc Code

PKG

27

m133153

27

D4730-020-030

Manufactured No

Each

0.0000

5/27/2016

2

D4730-020-030

Velcro Strip 2.0W/ X 3.0L

D4971-041

Manufactured No

Each

0.0000

**

11395572

11473927

D4971-041

T/R Bellcrank Cover Assembly

D5076-041

Manufactured No

Each

6.0000

**

139246

D5076-041

Fwd Bracket Assembly

Location

Loc Qty

Loc Code

ST624

4

130231

2

130749

2

ST636

2

130750

2

DAS
28
9-89

NOV 23 2015

BAS
27
9-89

Picklist Print

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Page 2

Work Order ID: 139245

Parent Item: D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

139245

D350-567-145

Start Date: 11/17/2015

Required Date: 11/25/2015

Start Qty: 2.00

Required Qty: 2.00

D3802-1

Manufactured

No

D3802-1

Windows Seal (\$ Per Foot)

DAS
27
9-89

1724 per h

DAS
28
9-89

Location
ST421

Loc Qty

Loc Code

90.75

90.75

134091

90.7500 2 4

**

DAS
27
9-89

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4435-9

Manufactured

No

D4435-9

Bracket

DAS
28
9-89

Location
ST098

Loc Qty

Loc Code

4

4

Each

4.0000 2 4

**

2x6/39314x2

DAS
27
9-89

D4436-041

Manufactured

No

D4436-041

Aft Bracket Assembly

DAS
28
9-89

Location
ST613

Loc Qty

Loc Code

4

4

f

4.0000 1 2

**

DAS
27
9-89

D4441-1

Manufactured

No

D4441-1

Rubber Seal

DAS
27
9-89

1724 per h

DAS
28
9-89

Location
ST407

Loc Qty

Loc Code

355.875

355.875

144.4944

144.4944

120932

ST422

120932

500.3694 2 4

**

DAS
27
9-89

(D4441-1-240) CUT (1) AT 24.00" PER KIT

NOV 23 2015

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Shop Packet Print

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Work Order ID: 139245

Parent Item: D350-567-145

139245

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/17/2015

Required Date: 11/25/2015

Start Qty: 2.00

Required Qty: 2.00

AN3-3A

Purchased

No

Each

231.0000

10

AN3-3A

Bolt

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST338a

135

m131624

135

ST350

96

m133483

96

Each

36.0000

4

**

AN525-10R6

Purchased

No

AN525-10R6

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST329

36

M131420

36

Each

44.0000

4

**

AN525-832R7

Purchased

No

AN525-832R7

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST328

44

m131957

44

Each

184.0000

14

**

MS21042106

Purchased

No

MS210421 06

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

178

m132803

30

m133316

48

m133363

100

ST305

6

m130325

3

m131317

3

NOV 23 2015

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Work Order ID: 139245

139245

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3c)

Start Date: 11/17/2015

Required Date: 11/25/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

Each

945.0000

2 4

MS21042L08

Nut

**

DAS 27 9-13

DAS 28 3-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

56

m133134

56

ST303

718

m133483

700

m133523

18

ST304

70

m128401

58

m131317

12

4

MS21042L3

Purchased

No

Each

517.0000

5 10

MS21042L3

Nut

**

DAS 27 9-13
NOV 23 2015

DAS 28 3-89

Location

Loc Qty

Loc Code

FP001

300

M130922

300

GA

90

M131317

90

ST304

127

M133498

127

10

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Page 4

Picklist Print

November 17, 2015 2:32:17 PM

Page 5

Work Order ID: 139245

139245

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/17/2015

Required Date: 11/25/2015

Start Qty: 2.00

Required Qty: 2.00

MS21059L3

Purchased

No

Each

197.0000

4

MS21059L3

**

Nut Plate

DAS 27 9-89

Location

Loc Qty

Loc Code

CA

16

M129682

16

cck007a

100

M133363

100

GA

3

I13749

1

M132677

2

ST301

45

M133031

45

ST303

33

M131616

7

M133016

26

DAS 28 9-89

MS35206-229

Purchased

No

Each

78.0000

14

MS35206-229

**

Screw

NOV 23 2015

Location

Loc Qty

Loc Code

ST277

78

M132763

78

DAS 28 9-89

DAS 27 9-89

Picklist Print

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Page 6

Work Order ID: 139245

Parent Item: D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

139245

D350-567-145

Start Date: 11/17/2015

Required Date: 11/25/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0332P

Purchased

No

Each

514.0000

10 20

NAS1149F0332P

Washer

**

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

132

122063

132

ST260a

130

m131026

80

m131697

50

ST262

135

m133284

135

st268

117

123900

7

m130388

86

m133077

24

NAS1149FN616P

Purchased

No

Each

148.0000

14 28

NAS1149FN616P

WASHER

**

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST267

148

M132763

148

NAS1149FN816P

Purchased

No

Each

788.0000

2 4

NAS1149FN816P

WASHER

**

DAS
6
9-89

NOV 23 2015
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

st268

788

117316

788

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Shop Packet Print

Page 6

DART SERVICE INSTRUCTION

20150117

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. E OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-18
FAA STC: SH989NE
FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350 B3e aircraft.

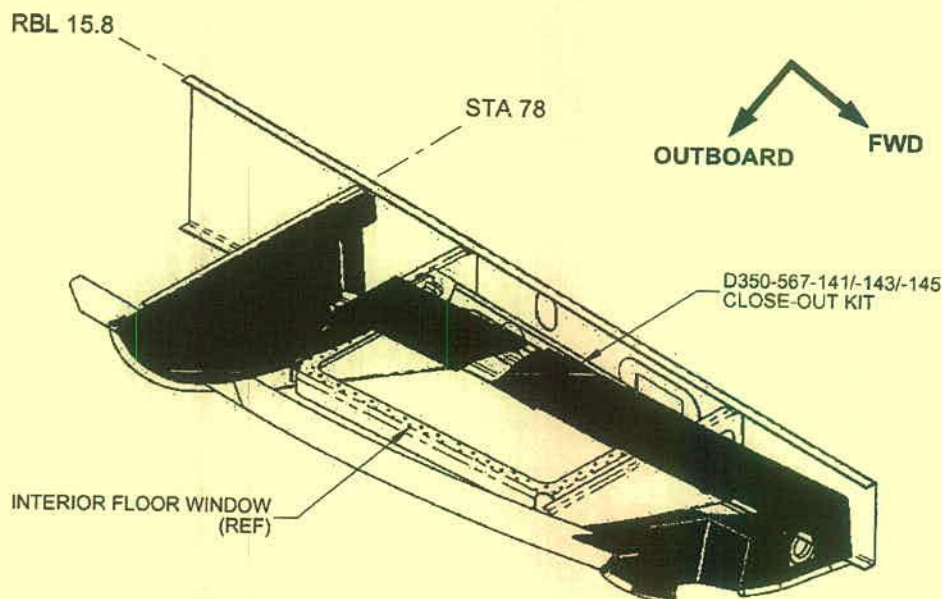


Figure 1. Floor Window Close-out Kit Installation

F	ADDED D4434-047 TO -141 KIT SEE PAR14-372.	AJS	15.01.12
E	ADD -143/-145 KITS	RF	14.03.20
E	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6, NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN815P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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DAO # 01-O-01

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BY: 
D. SHEPHERD (DE # 02)

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ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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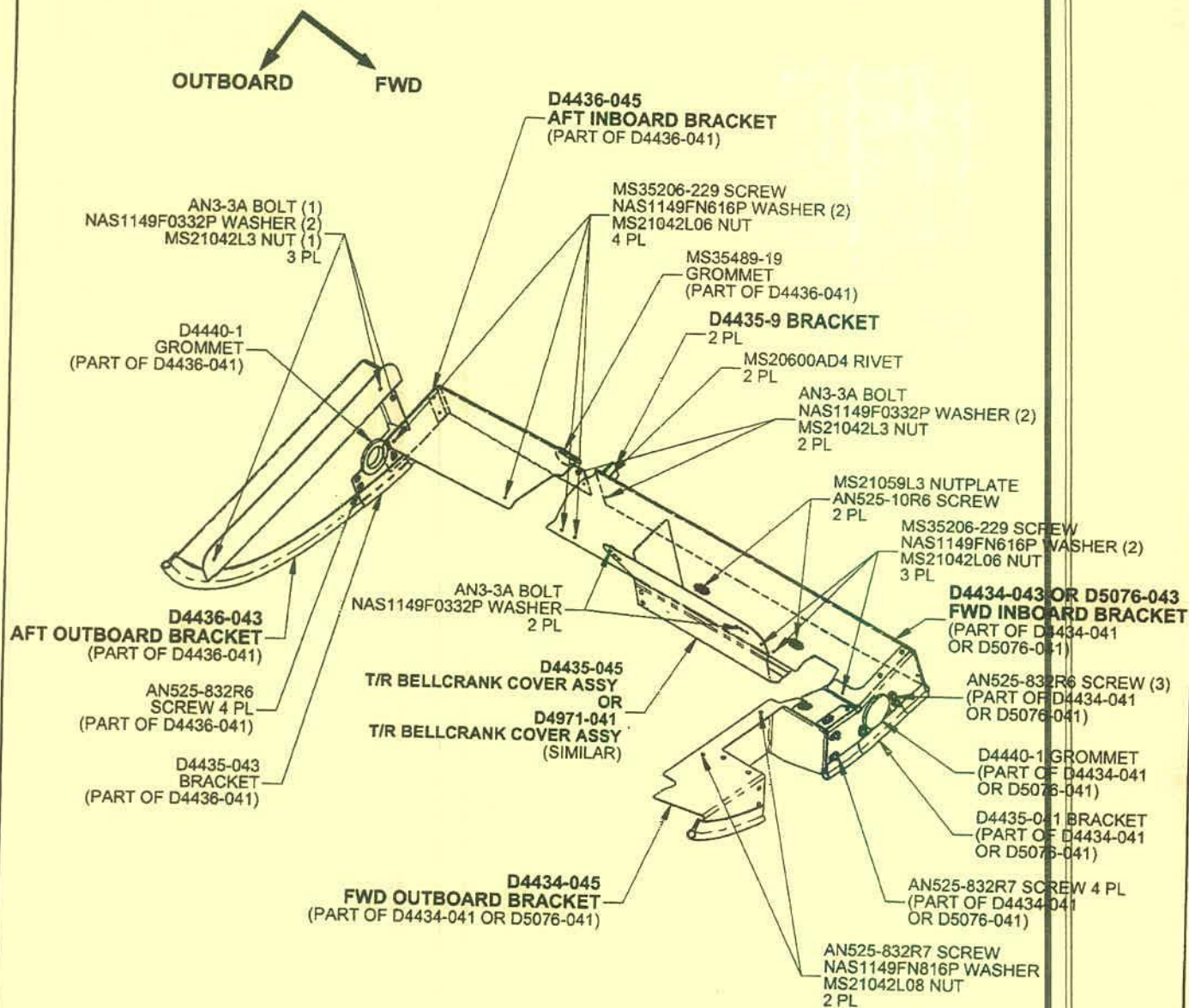


Figure 2. Floor Window Close-out Kit Installation

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DAO # 01-Q-01

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DATE: 15.01.12
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ISSUE NO.: 6

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DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:

- a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
- b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

F 4.3 For -141 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.4 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.5 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.6 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill $2 \times \varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill $2 \times \varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.7 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.8 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill $2 \times \varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.9 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.10 Transfer drill $2 \times \varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill $2 \times \varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.

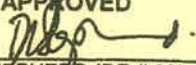
4.11 FOR D350-567-141 KIT

a) Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.

b) Transfer drill $2 \times \varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

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DAO # 01-O-01

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BY: 
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DATE: 15.01.12
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ISSUE NO.: 6

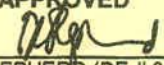
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 4 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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4.12 FOR D350-567-143/-145 KIT

- a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.
 - b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.
 - c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CB 200 adhesive.
 - d) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-1CR6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
 - e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.13 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.14 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.15 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.16 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141 /-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

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BRANCH
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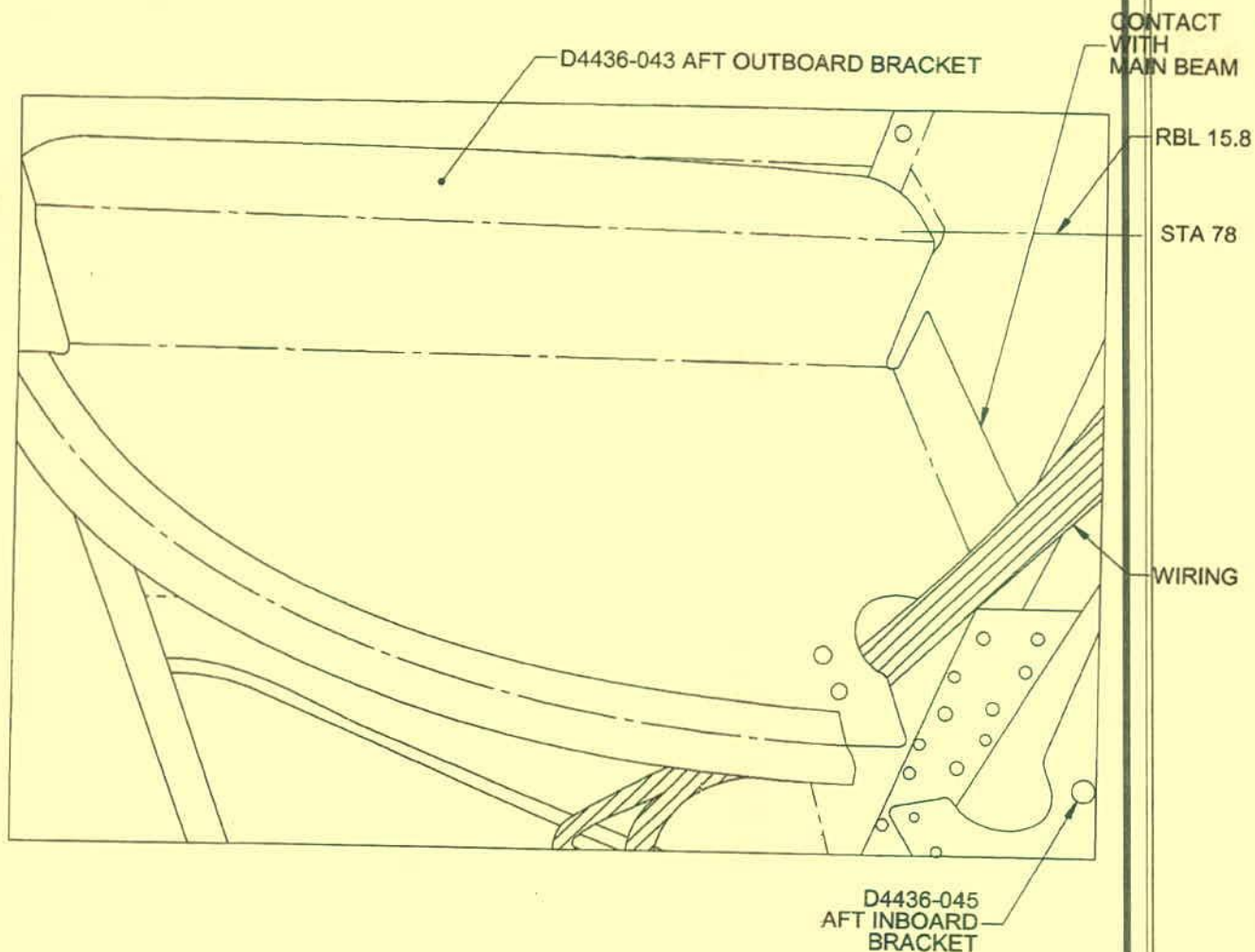


Figure 3. D4436-043 Aft Outboard Bracket Installation

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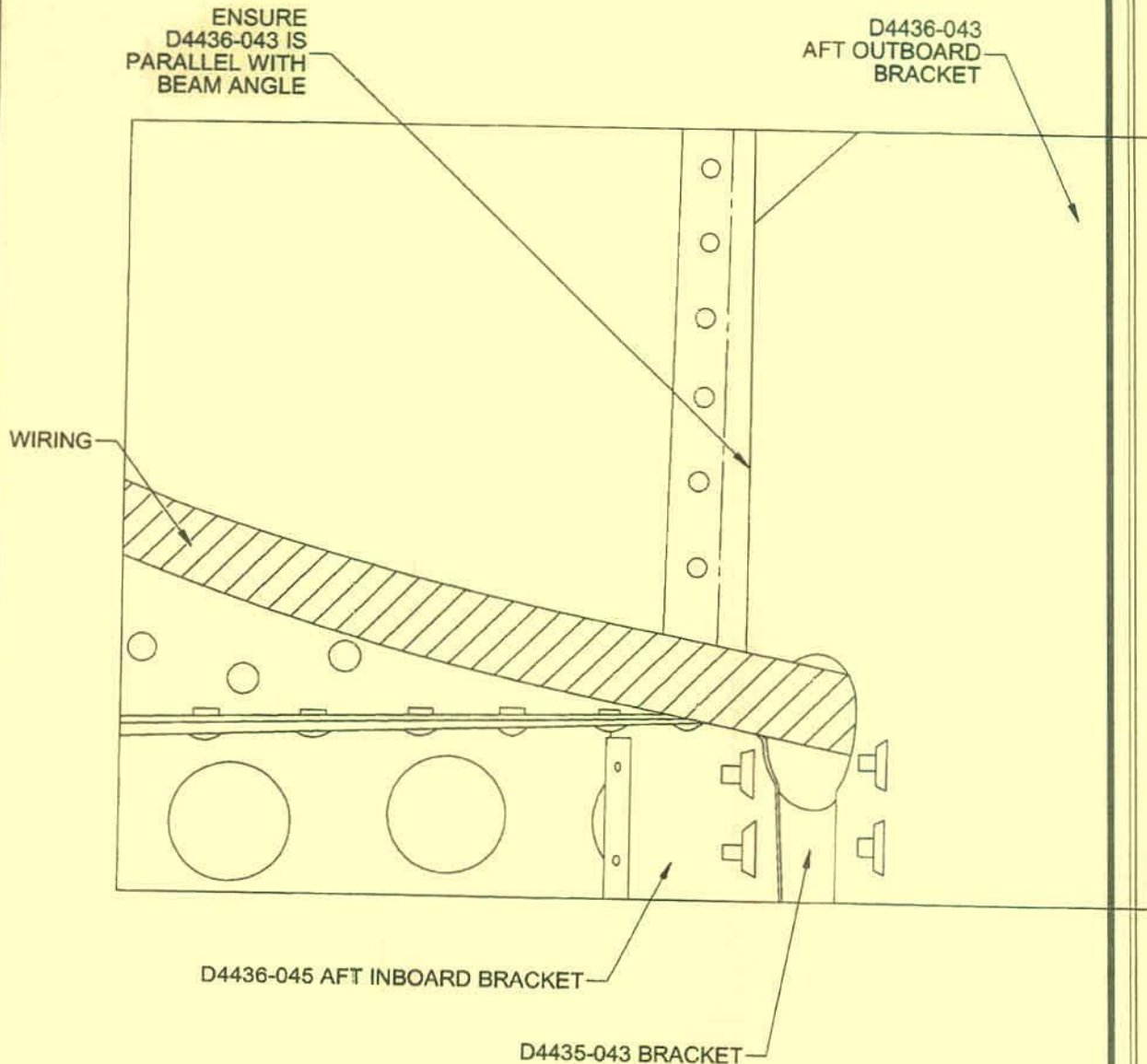


Figure 4. D4436-043 & D4435-043 Brackets Installation

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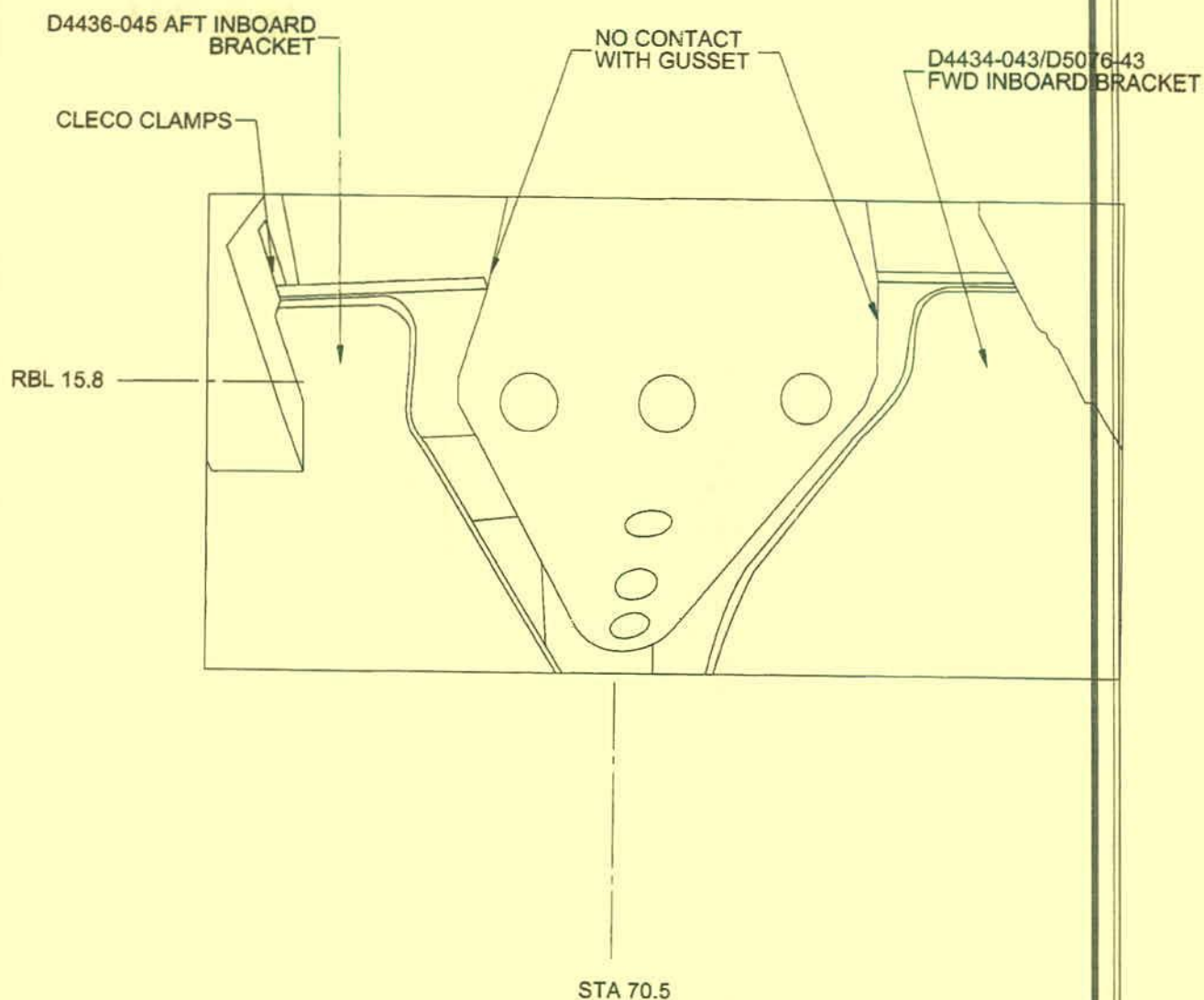


Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation

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D4436-043
AFT OUTBOARD
BRACKET

CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

WIRING

PLASTIC STAND OFF
REF

RIVET HOLE
FOR PLASTIC
STAND OFF

CLECO CLAMPS

D4436-045
AFT INBOARD
BRACKET

Figure 6. D4436-043 & D4436-045 Brackets Installation

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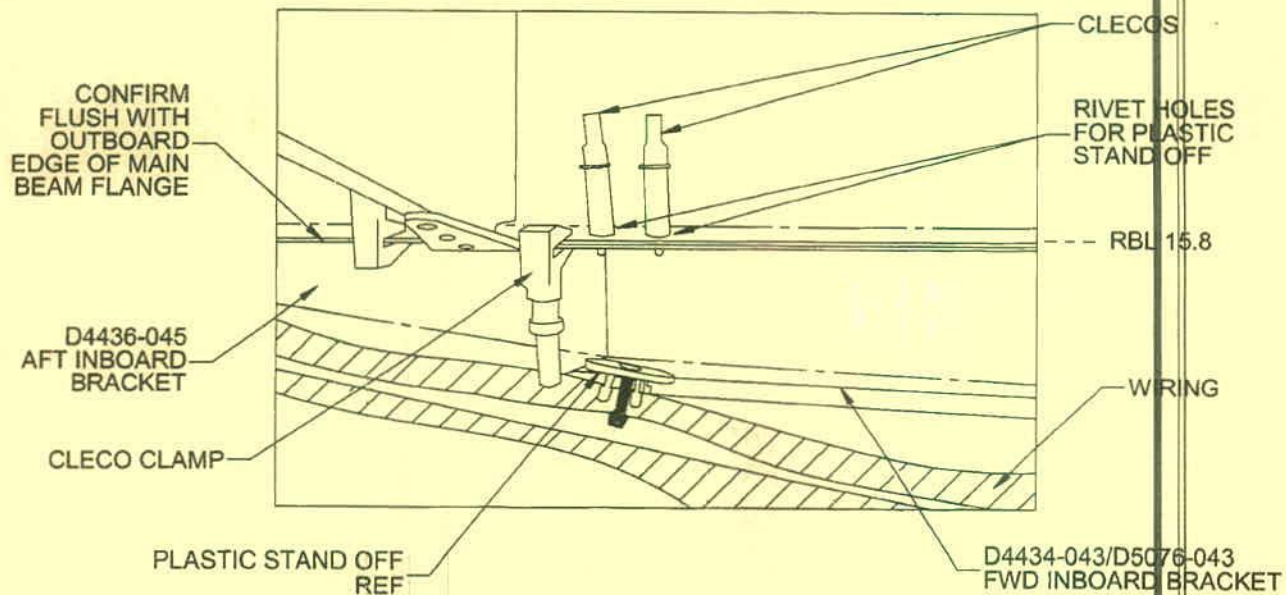


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

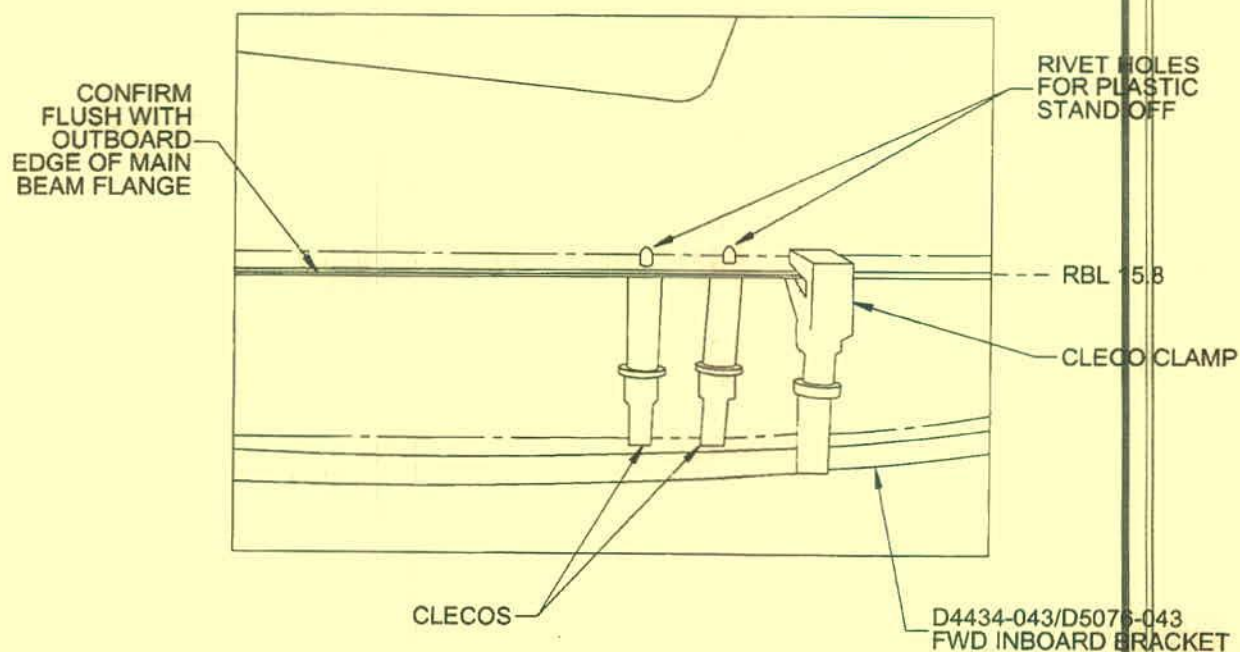


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation

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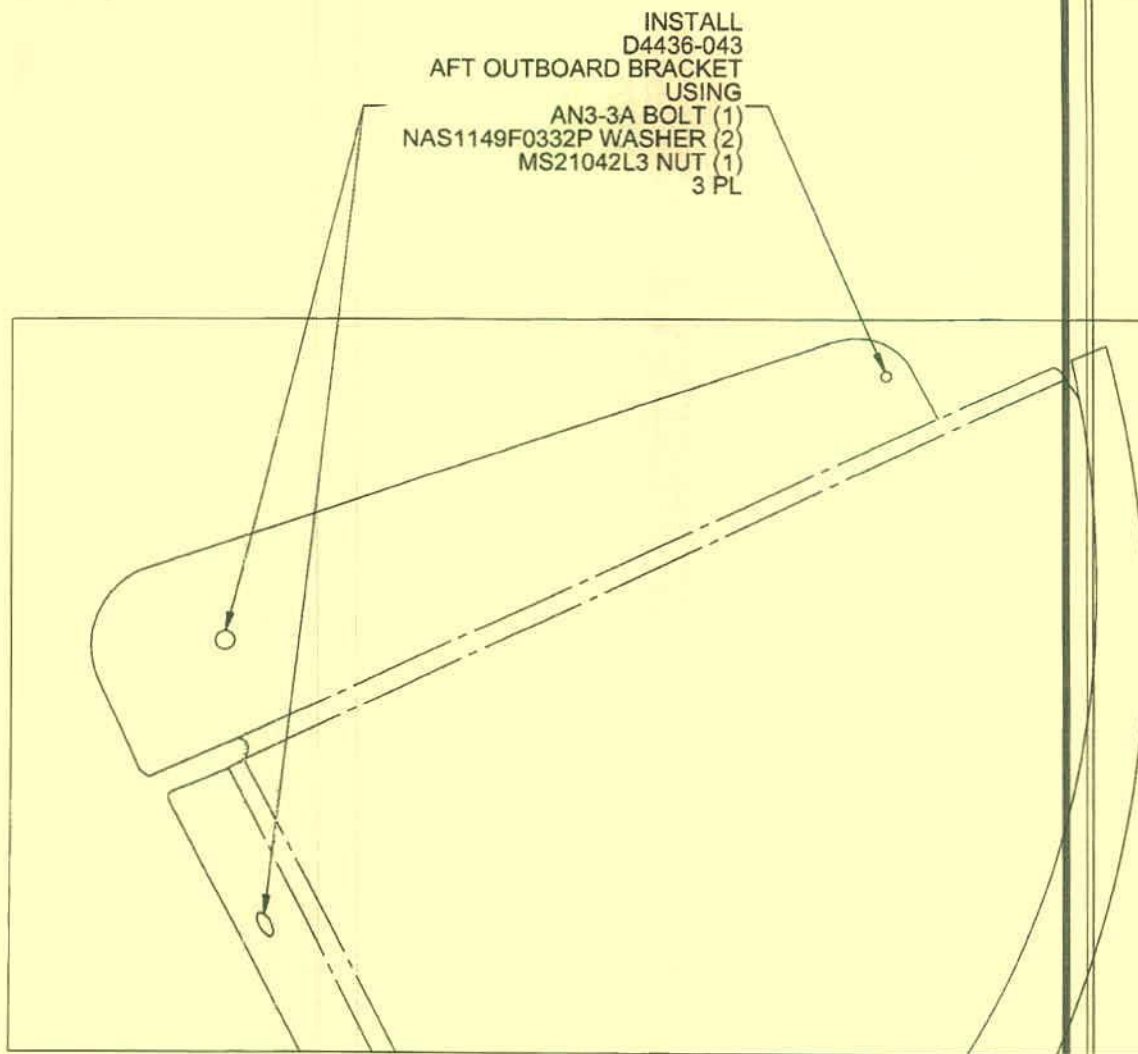


Figure 9. D4436-043 Aft Outboard Bracket Installation

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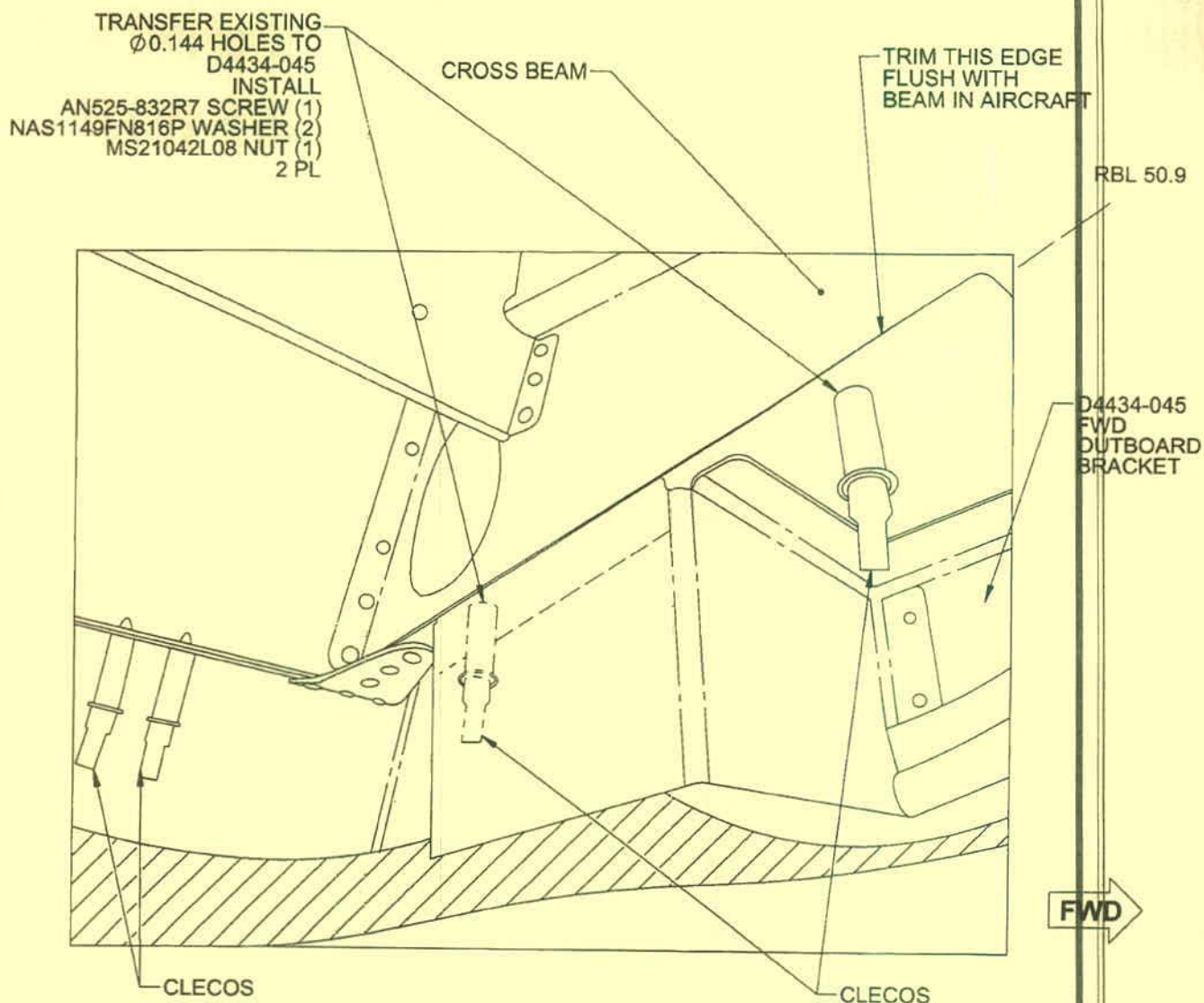


Figure 11. D4434-045 Bracket Installation

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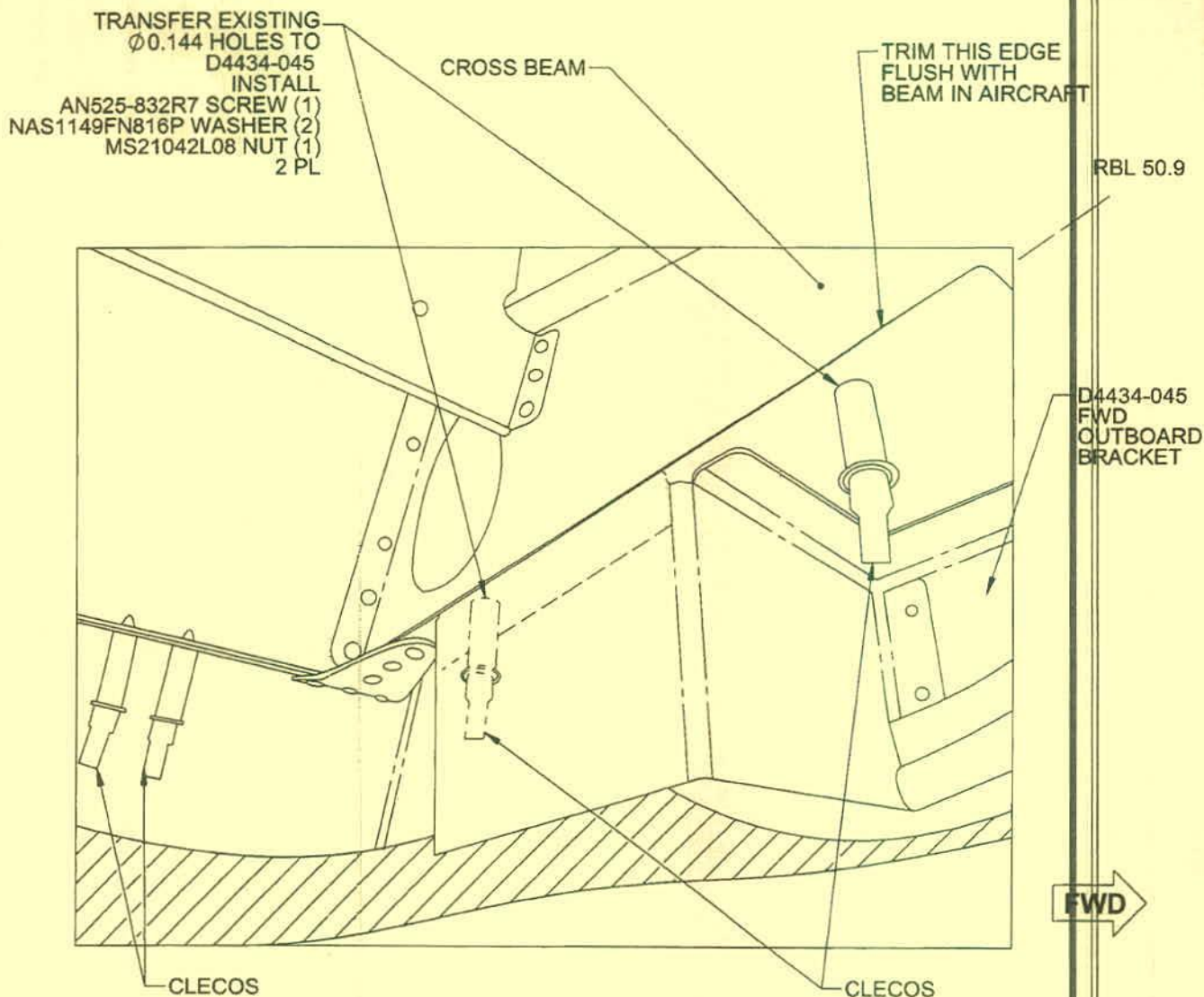


Figure 11. D4434-045 Bracket Installation

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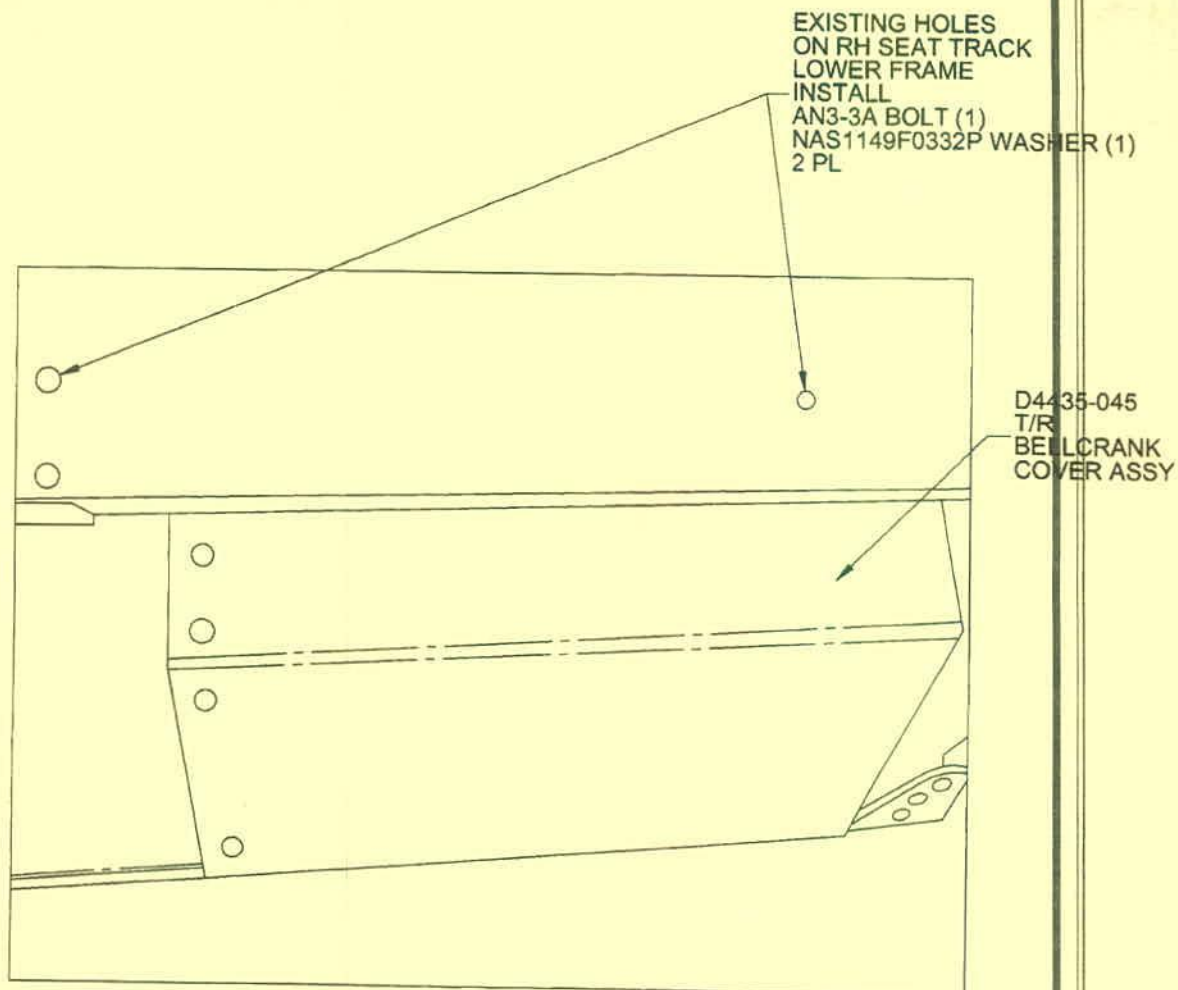


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

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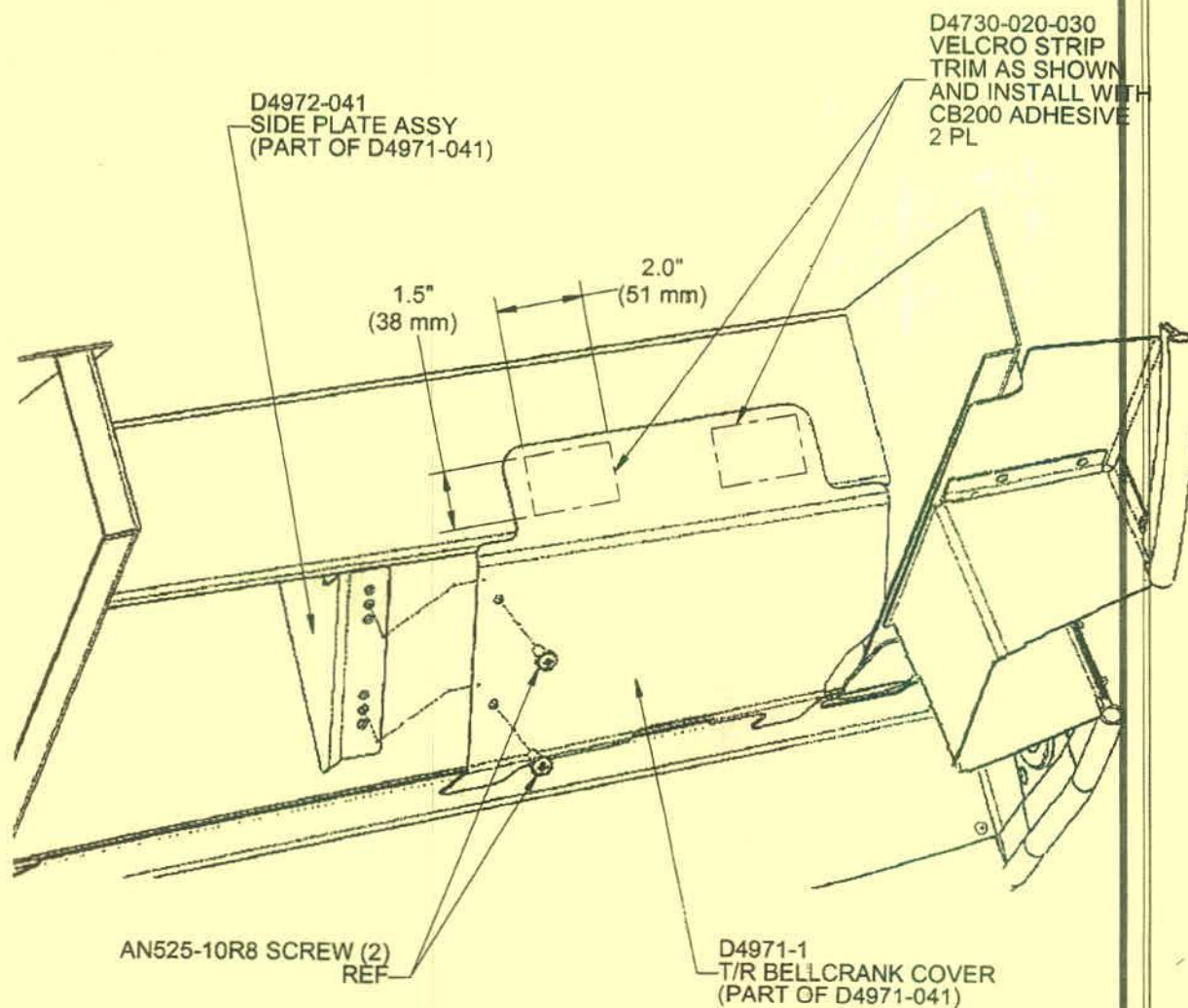


Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

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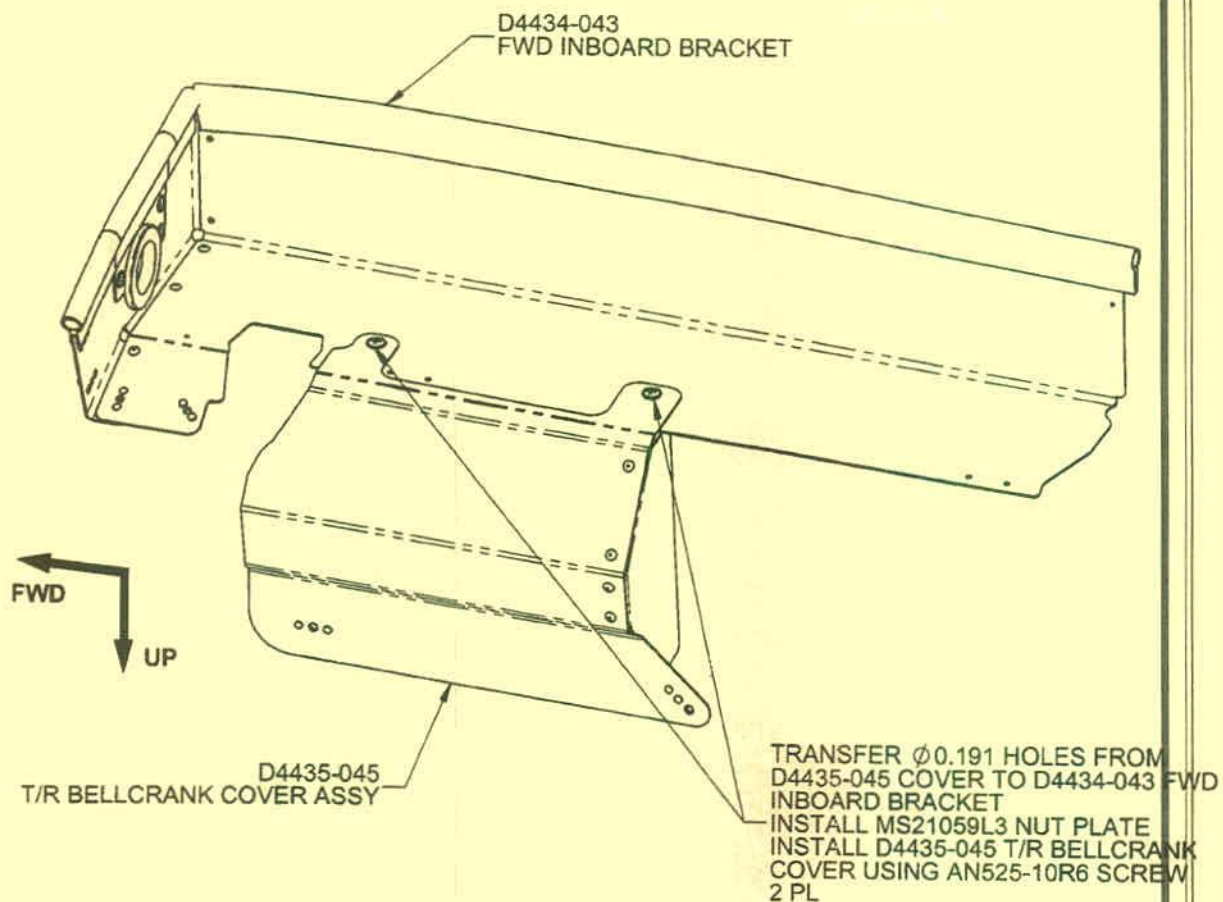


Figure 13a. D4435-045 Cover Installation (-141 ONLY)

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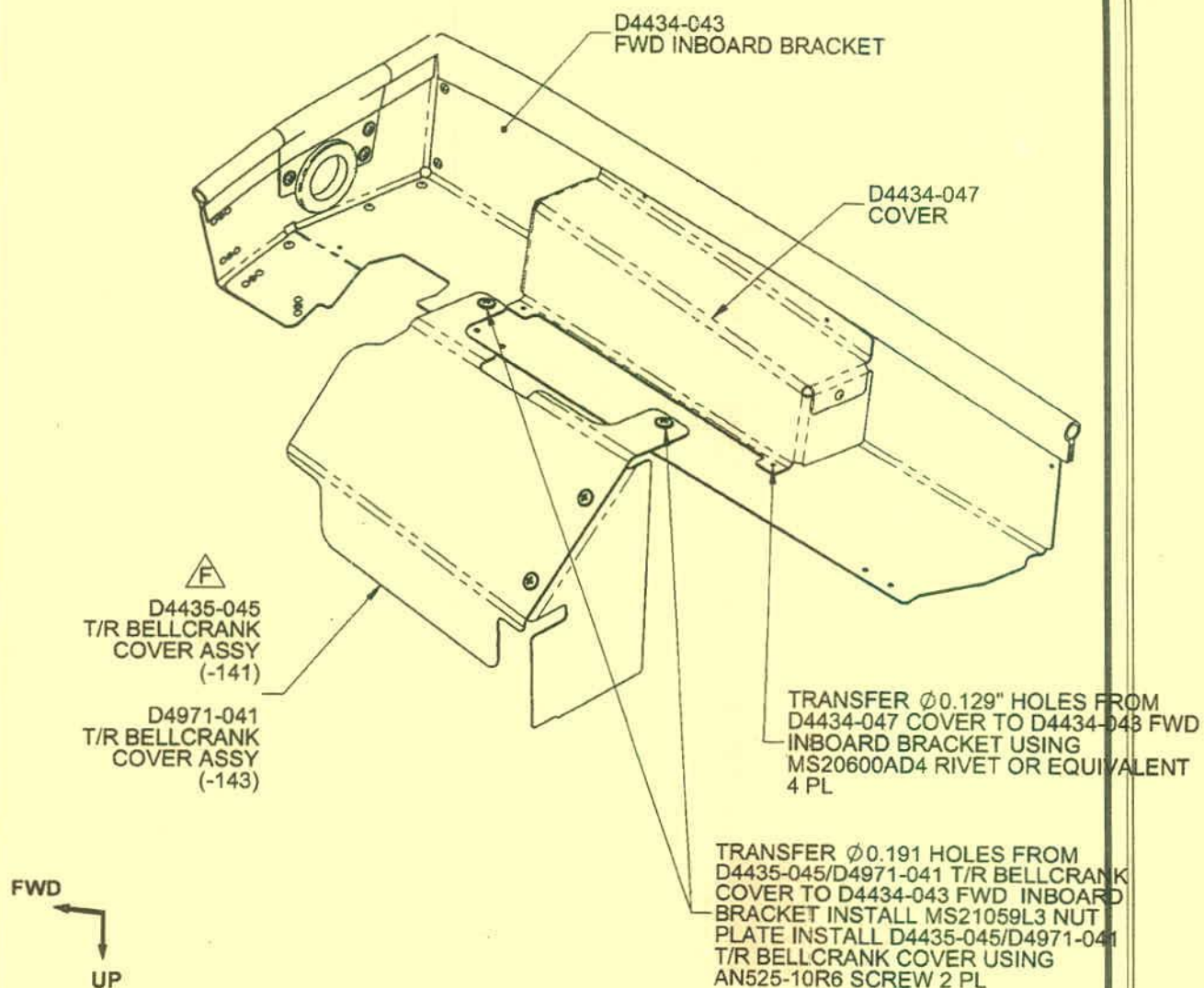


Figure 13b. D4971-041/D4435-045 & D4434-047 Cover Installation
(D4434-047 is Optional on -141)



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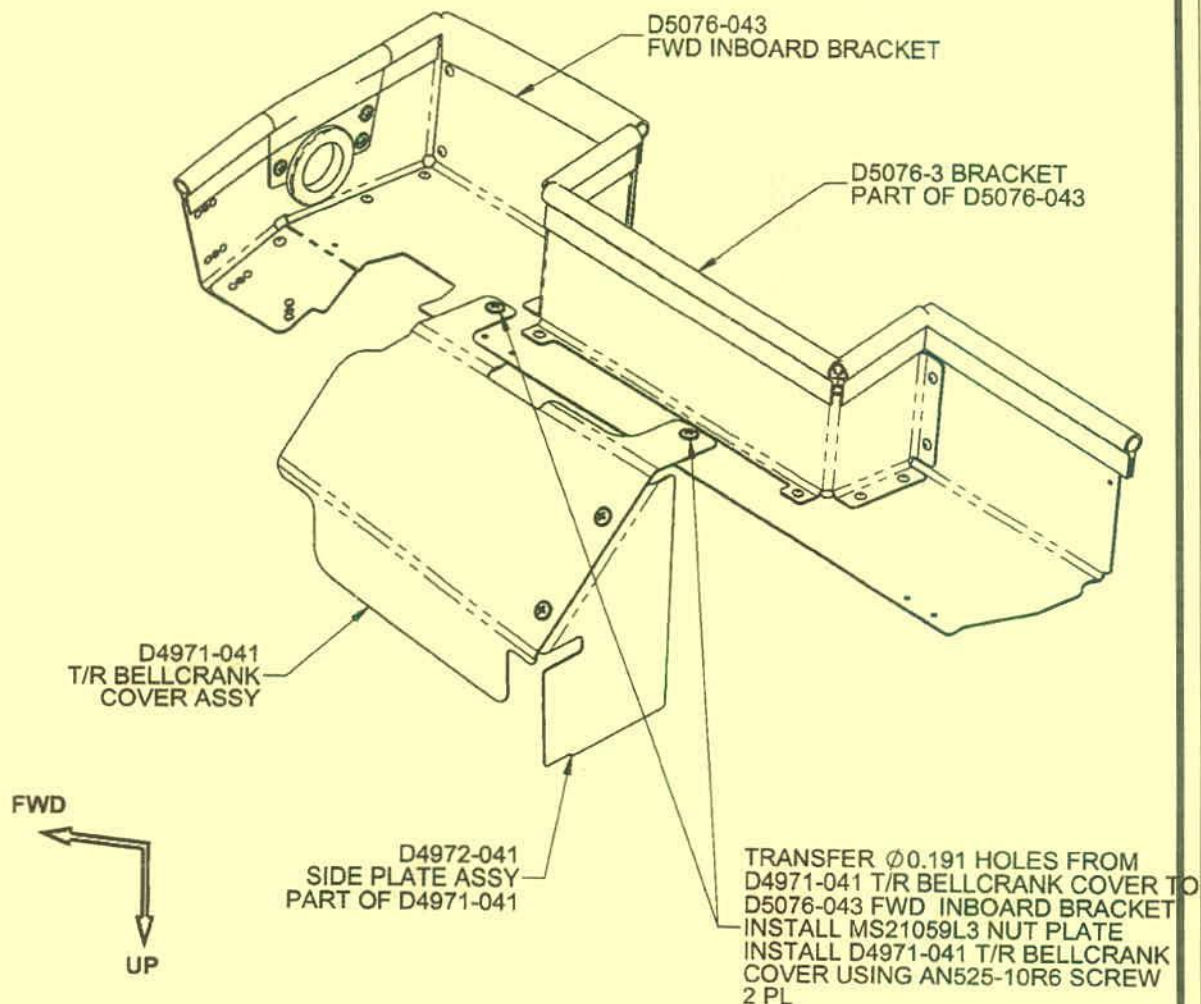


Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)

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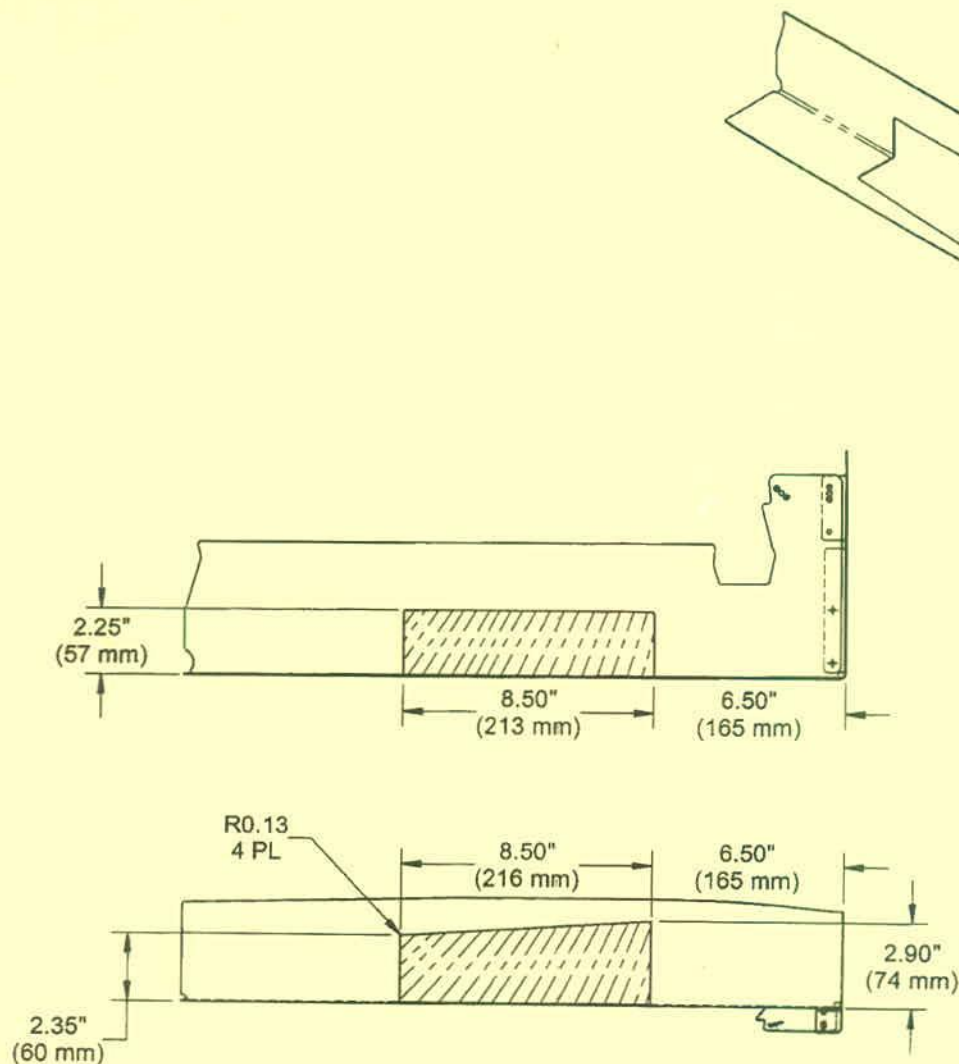


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kG	65.5 in 1.66 m	255.5 in-lb 2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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To ship Nov 25

Page 1

Item ID: D350-567-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 11/17/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/25/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: SA

Date: 11/17/15

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9590	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-145 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

ML5

15-11-23

2

NOV 23 MON